

Date: Wednesday, 12/5/2007 3:43:44 PM
User: Kim Johnston

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D407667105A
Job Number : 36157
Estimate Number : 10804
P.O. Number : N/A
This Issue : 12/5/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : 35894
Written By :
Checked & Approved By : 071205
Comment :

Part Number : D407667105
Drawing Number : REWORK
Project Number :
Drawing Revision :
Material :
Due Date : 12/12/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE FROM STOCK:

1 X D407-667-105A B34327

STRIP P746 ARMOR SHIELD

DART

TRANSPORT CANADA APPROVAL #09-89

TEL: 1-613-632-3336
FAX: 1-613-632-4443

P/N	D407-667-105A	QFC	CHG001
DESC	Crosstube Fwd High	SIC	SH01-5
LOT	B34327	SIC	SR01304NY
MODEL	Bell 407	SIC	

MADE IN CANADA

2.0 D407667105A Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Crosstube Installation W/ armour shield

3.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING
RE-SPARY PAINT CROSSTUBE
WHITE IMRON PER QSI 005 4.2

ml 071213 (1)

PTO →

4.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

a 7/12/20

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



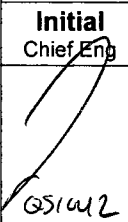

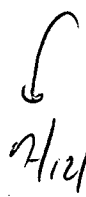
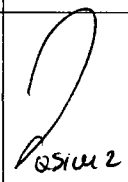

Comment: LANDING GEAR RESOURCE 1
REASSEMBLE PER DRWG D407-667-105
USING EXISTING HARDWARE
RECORD ANY NEW HARDWARE:

ml 071214 (1)
Abrasion strip: B28656 (cut to 4')
Clamp: B103478

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/13	3.0	Paint was very light on both sides of X-tube primer was showing.		Sand & re-paint as per QSi 005	 07/12/13	 7/12/20		 07/12/13

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 3:43:44 PM
User: Kim Johnston

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407667105A

Job Number: 36157

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 2/12/20 60

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Rev B

7/12/27

50 2



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

USING NEW B/N

ENSURE ORIGINAL KIT IS IN BOX.

7/12/10 50 1x

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/28/10/03

Job Completion



2008/1/3 02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED DS	DRAWING NO. D407-667-145	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE NTS
A	02.05.08	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

UNDER REVIEW
06.08.10
redraw detail
PH
07.06.19

Qty	Part Number	Description
X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
1	D6010-115	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-20	CLAMP

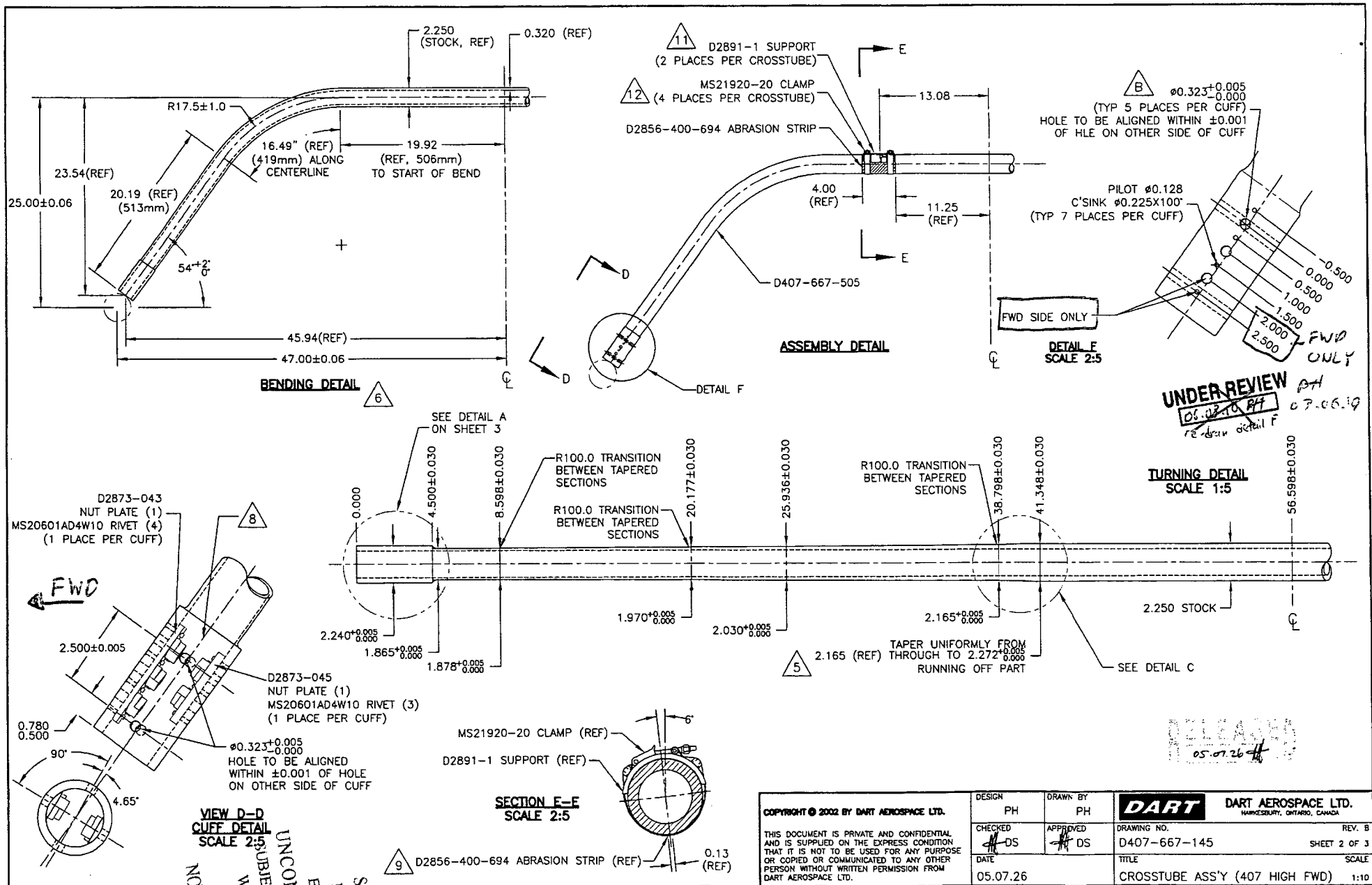
GENERAL NOTES:

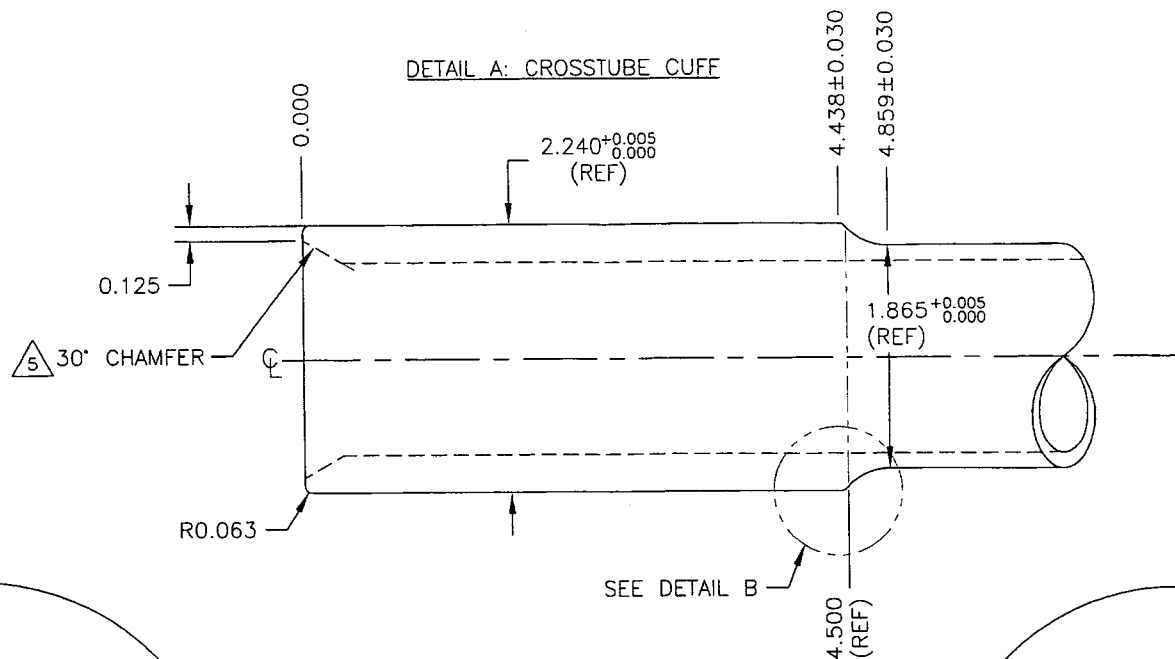
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT, (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3615

Copyright © 2002 by DART AEROSPACE LTD

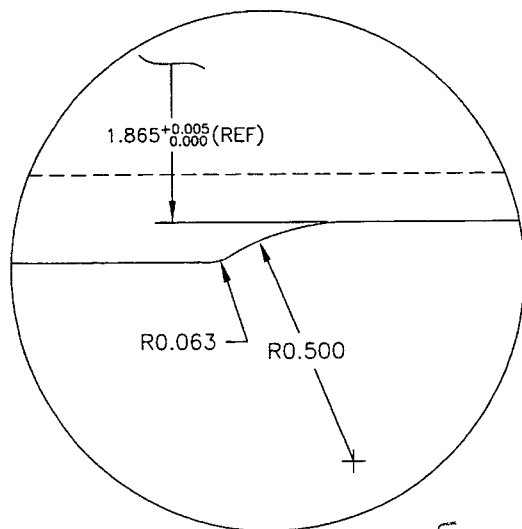
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



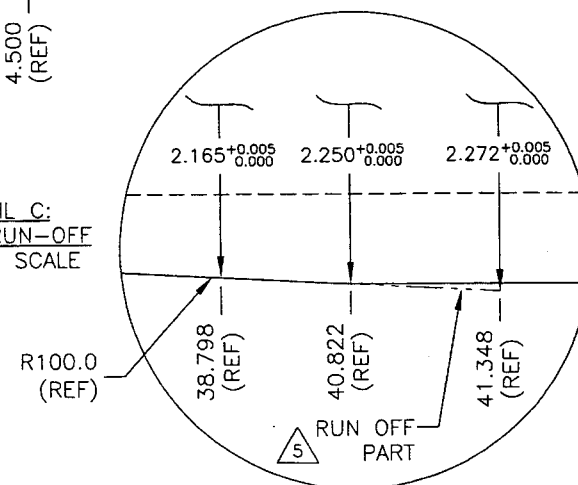


UNDER REVIEW PH
 05.07.10 PH
 Fe-draw detail F 02.06.10

RELEASED
 05.07.10



DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 36157

COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMMERSBURG, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		PH	PH		
CHECKED		PH	PH	DRAWING NO.	REV. B
DS		DS	DS	D407-667-145	SHEET 3 OF 3
DATE		05.07.26		TITLE	SCALE
				CROSSTUBE ASS'Y (407 HIGH FWD)	1:1

YELLOW

(YFSY)

FED. I.D. #44-0594706

CONSIGNEE
DELIVERY
RECEIPT

12/10/07

06:09 345

FREIGHT BILL NUMBER

305-311078

2

BILL DATE 12/05/07

DEST/ORIG: DTW/LAF

CHECK
DIGIT

START AEROSPACE LTD

1270 ABERDEEN ST

CHAMBERSBURG ON K&A 1K7

BRIGITTE GOLDEN 613-632-5200

OFFSHORE HELICOPTER SUPPORT SERV

1000 BURGESS DR

THIBODIAUX LA 70513

SHIPPER'S PHN ***337-819-0500

N/A BLW

SHIPPER'S N/A BLW

QUESTIONS? CONTACT CUSTOMER SERVICE 24 HOURS A DAY AT:

1-800-610-6500

YOU MAY REQUEST PICKUPS, TRACE SHIPMENTS OR LEARN MORE
ABOUT OUR OTHER SERVICES AT: www.myyellow.com

SPECIAL INSTRUCTIONS

I/B
TRLR# 0128098

CHKR PCS DATE

CITY TRLR# DOCK

LDR PCS DATE

DELIVERED BY

PCS DATE TIME

PIECES	PKG	DESCRIPTION	CLASS	WEIGHT LBS.	RATE	EXTENSIC
--------	-----	-------------	-------	-------------	------	----------

*** EXACT EXPRESS: TIME ARRIVED AT CONSIGNEE TO MAKE DELIVERY ***

2		BOXES AIRCRAFT PARTS CL 200		200		340.4
2		BOXES AIRCRAFT PARTS CL 70		80		
		OVER DIMS TIER 1 GROUND-COL				140.0
		BORDER CHARGE US-CAN GROUND-COL				
		FUEL SURCHARGE-EE-25.0% INCREASE-COL			725.0	85.1
		SINGLE SHIPMENT				

*** DIMENSION INFO ***

PIECES LENGTH WIDTH HEIGHT

2 150 12 6

2 20 12 74

PCS	RECEIVED IN GOOD CONDITION AND SERVICE AUTHORIZED EXCEPT AS NOTED BY	C.O.D. AMT:	TTL WEIGHT LBS.	PPD/COLL	TTL FREIGHT CHG
-----	--	-------------	-----------------	----------	-----------------

INSIDE DELIVERY	<input type="checkbox"/>	LIFT GATE	<input type="checkbox"/>	# PIECES SORT & SEG	<input type="checkbox"/>	RESIDENTIAL DELIVERY	<input type="checkbox"/>	CONSTRUCTION SITE DELV	<input type="checkbox"/>	WAIT TIME START	END	AUTHORIZED PHONE #	() -
--------------------	--------------------------	--------------	--------------------------	------------------------	--------------------------	-------------------------	--------------------------	---------------------------	--------------------------	--------------------	-----	--------------------	-------

PAYABLE BY CASH OR CERTIFIED
CHECK UNLESS OTHERWISE NOTED

TTL WEIGHT LBS. PPD/COLL TTL FREIGHT CHG

COL NEXT PAGE

Date:
User:Wednesday, 12/5/2007 3:43:44 PM
Kim Johnston

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D407667105A
Job Number	: 36157		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D407667105
This Issue	: 12/5/2007 S.O. No. :	Drawing Number	: REWORK
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 35894	Material	:
Written By	:	Due Date	: 12/12/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 011205</u>		
Comment	:		

Additional Product

Rework + Labels CHG 002

07.12.06 JA

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE FROM STOCK:

1 X D407-667-105A B34327

STRIP P746 ARMOR SHIELD

2.0

D407667105A

Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Installation W/ armour shield

3.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RE-SPARY PAINT CROSSTUBE

WHITE IMRON PER QSI 005 4.2

4.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REASSEMBLE PER DRWG D407-667-105

USING EXISTING HARDWARE

RECORD ANY NEW HARDWARE: